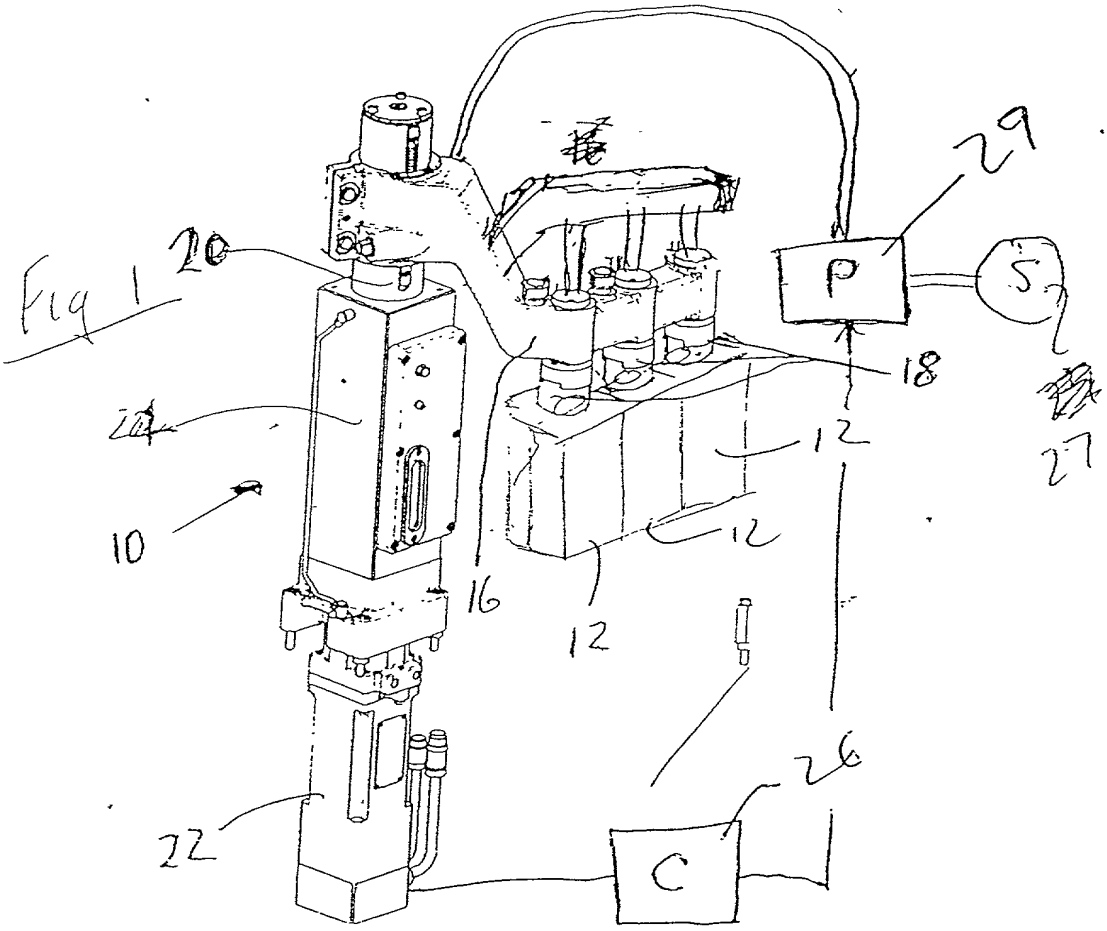


Fig 1
20
29
P
S
18
14
12
10
16
12
12
27
22
26
C

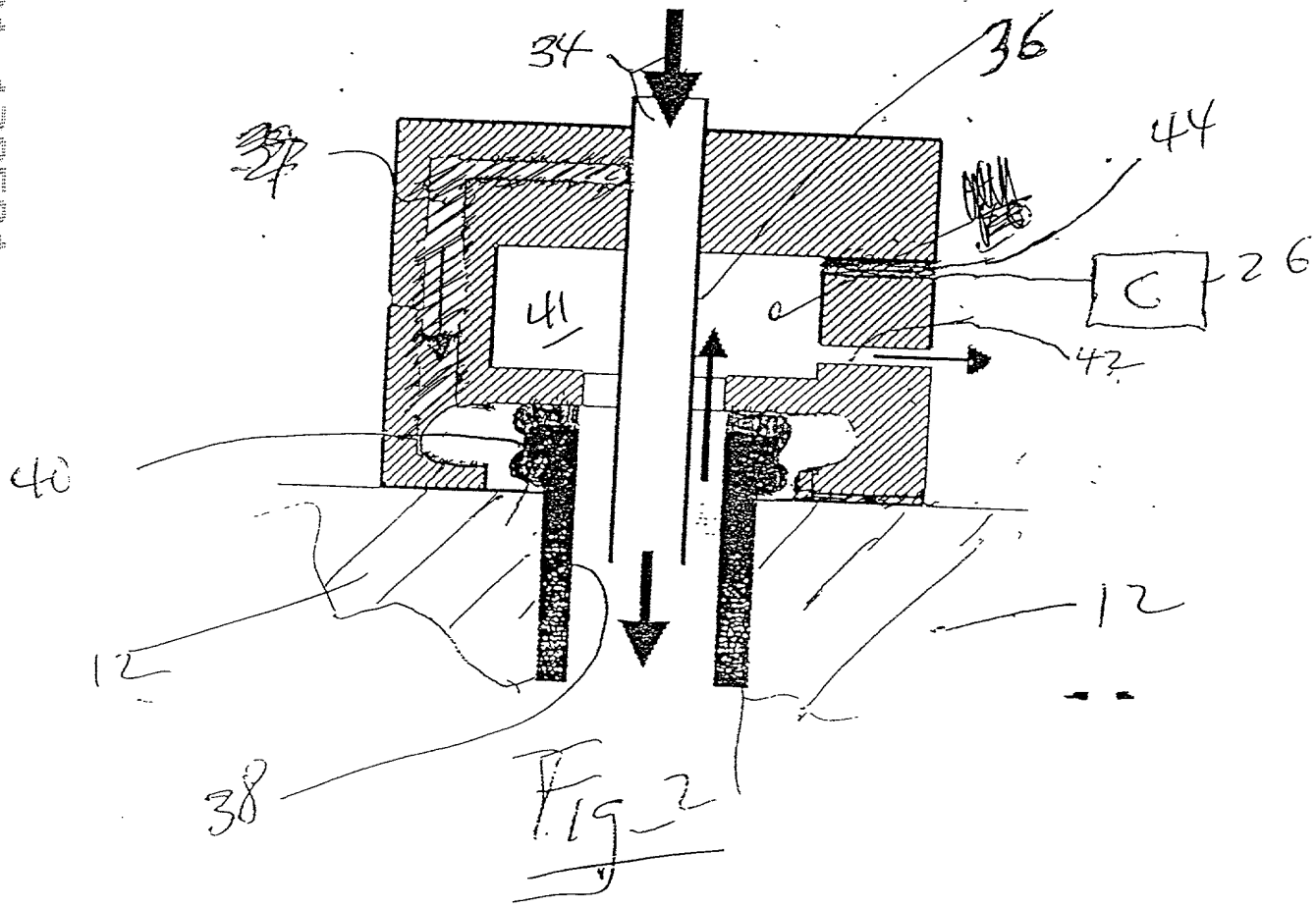

34
36
44
41
C
26
42
40
12
12
38

Fig 2

T0502T "T24S000T

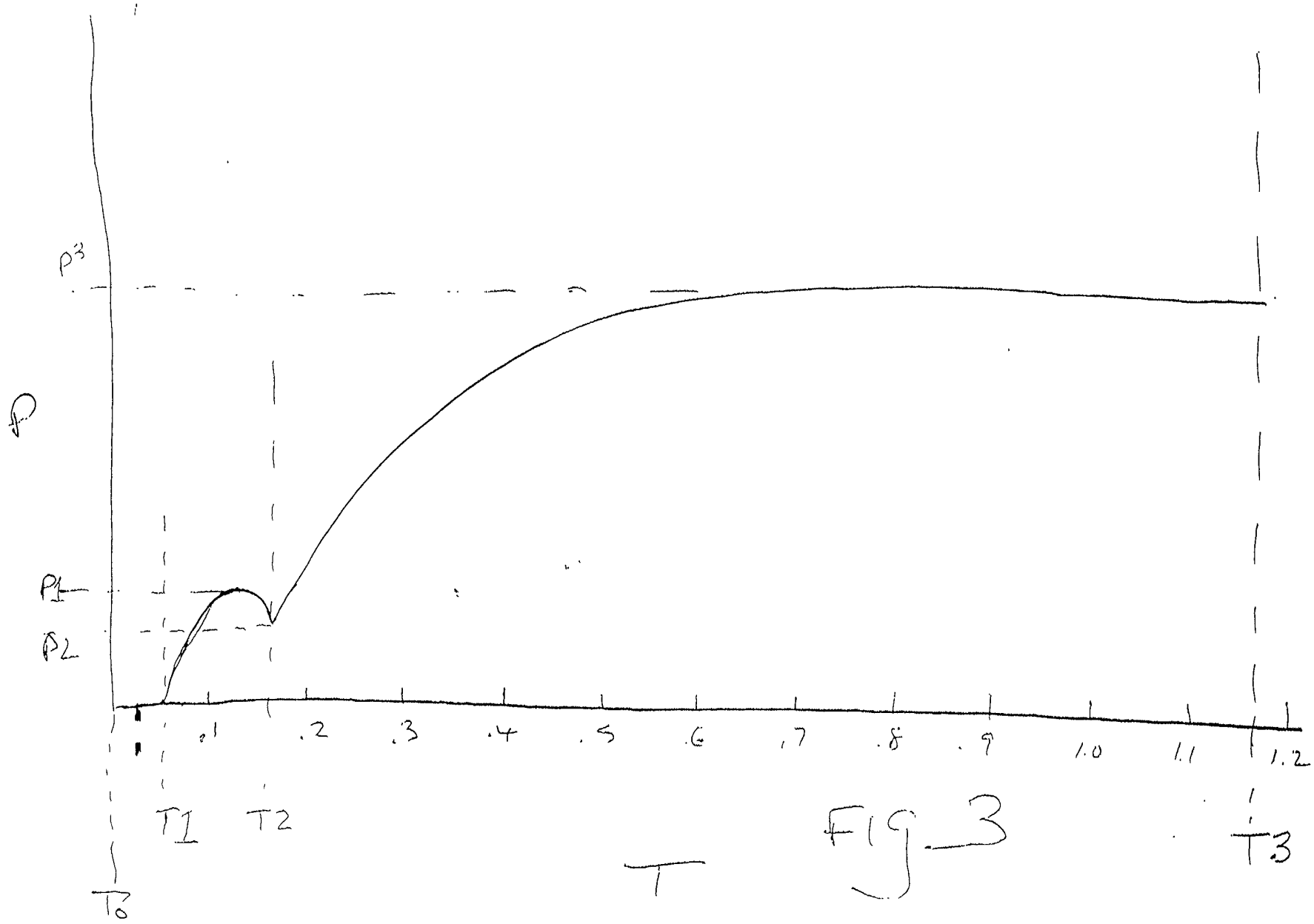


FIG 3

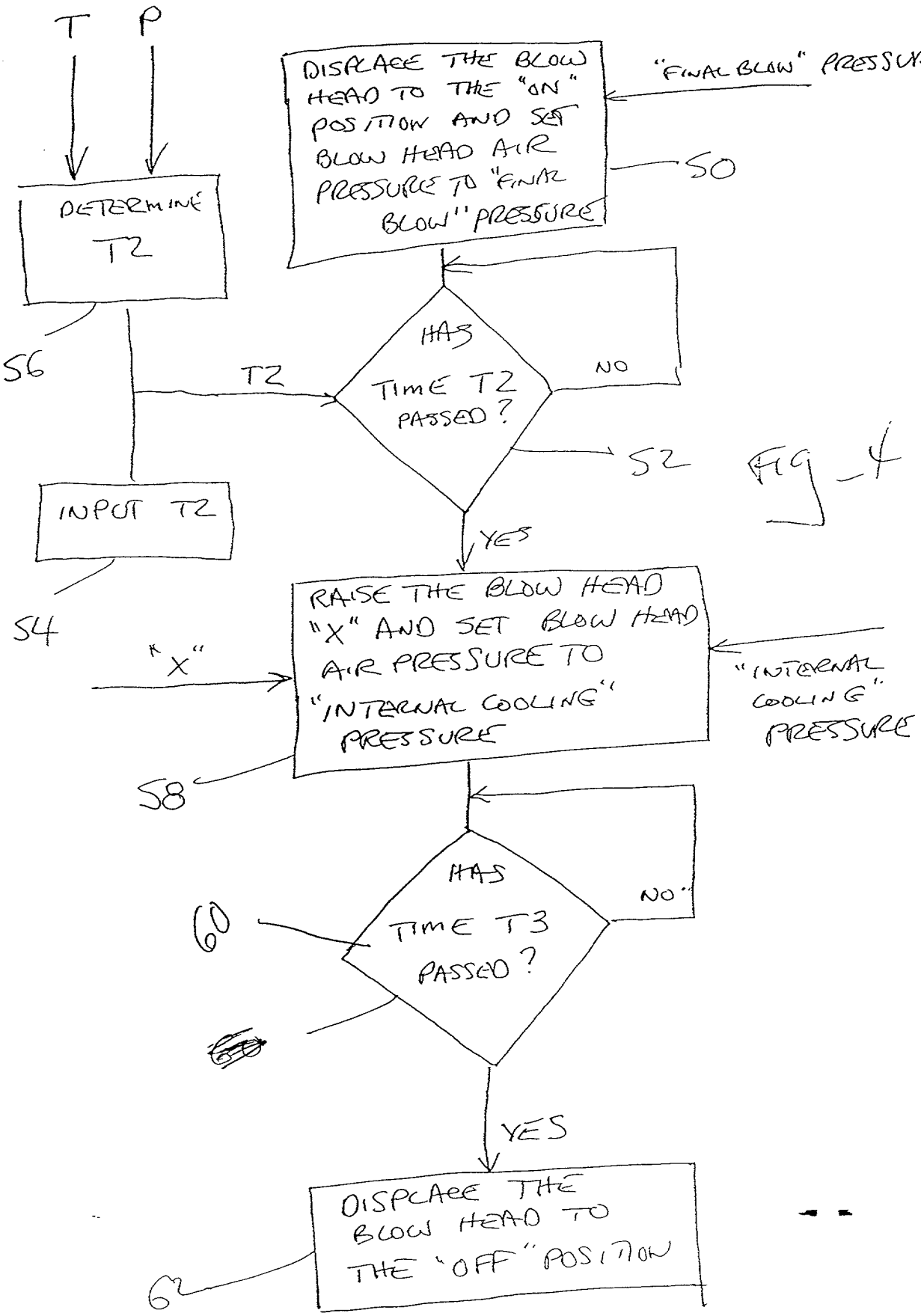

T
P
DISPLACE THE BLOW HEAD TO THE "ON" POSITION AND SET BLOW HEAD AIR PRESSURE TO "FINAL BLOW" PRESSURE
"FINAL BLOW" PRESSURE
50
DETERMINE T2
56
T2
HAS TIME T2 PASSED?
NO
52
YES
INPUT T2
54
"X"
RAISE THE BLOW HEAD "X" AND SET BLOW HEAD AIR PRESSURE TO "INTERNAL COOLING" PRESSURE
"INTERNAL COOLING" PRESSURE
58
HAS TIME T3 PASSED?
NO
60
YES
DISPLACE THE BLOW HEAD TO THE "OFF" POSITION
62

Fig_4

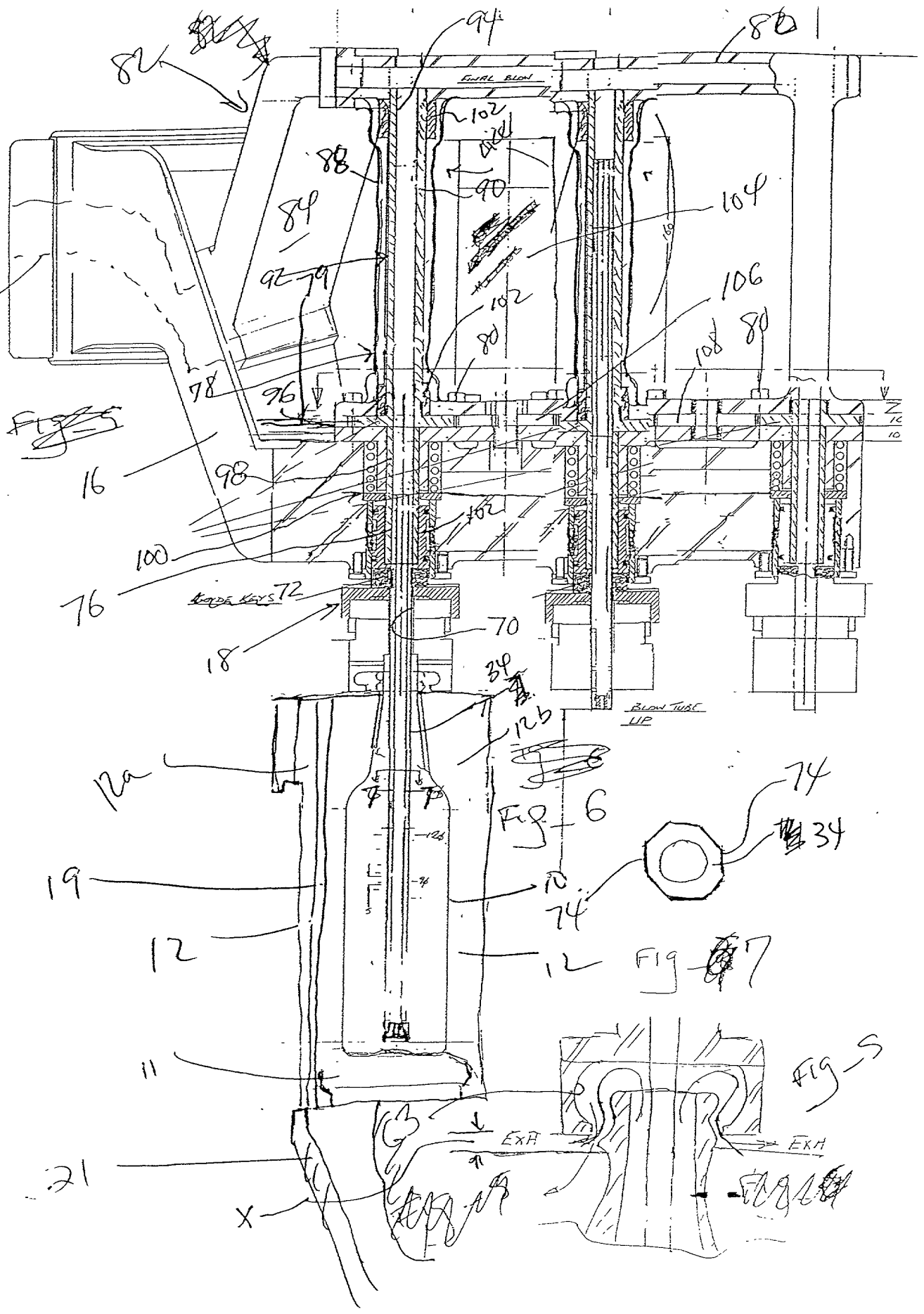


Fig 6

Fig 7

Fig 5

Fig 4

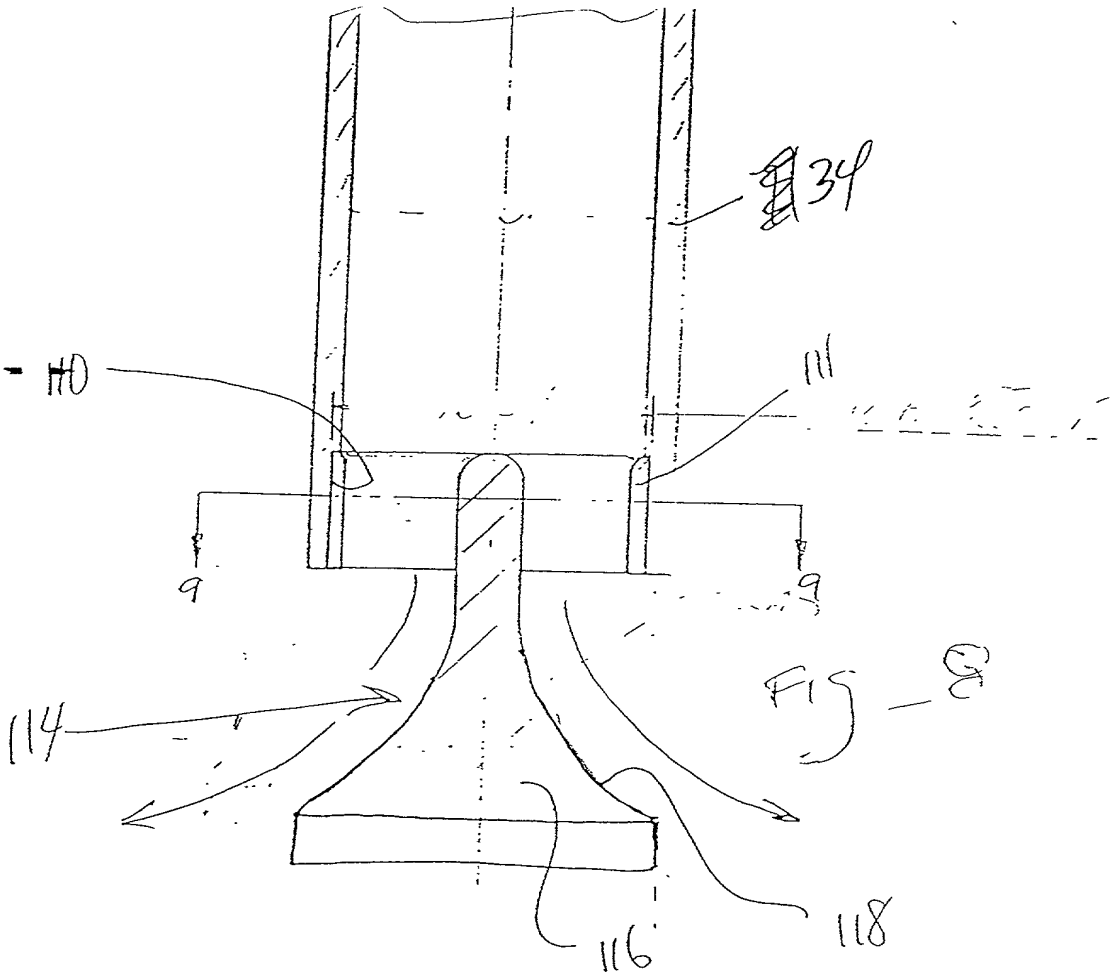


Fig - 8

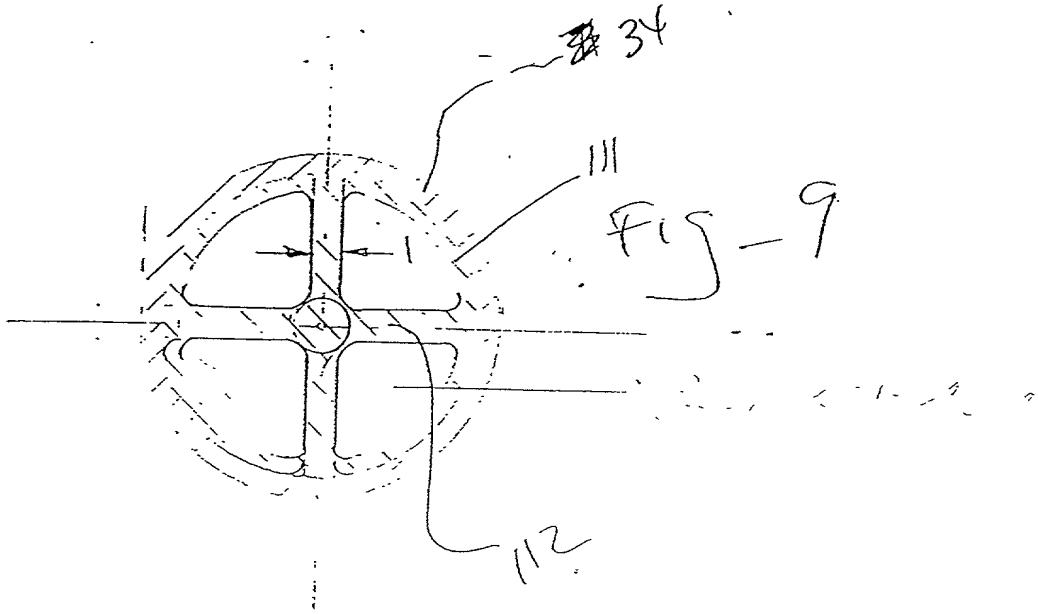
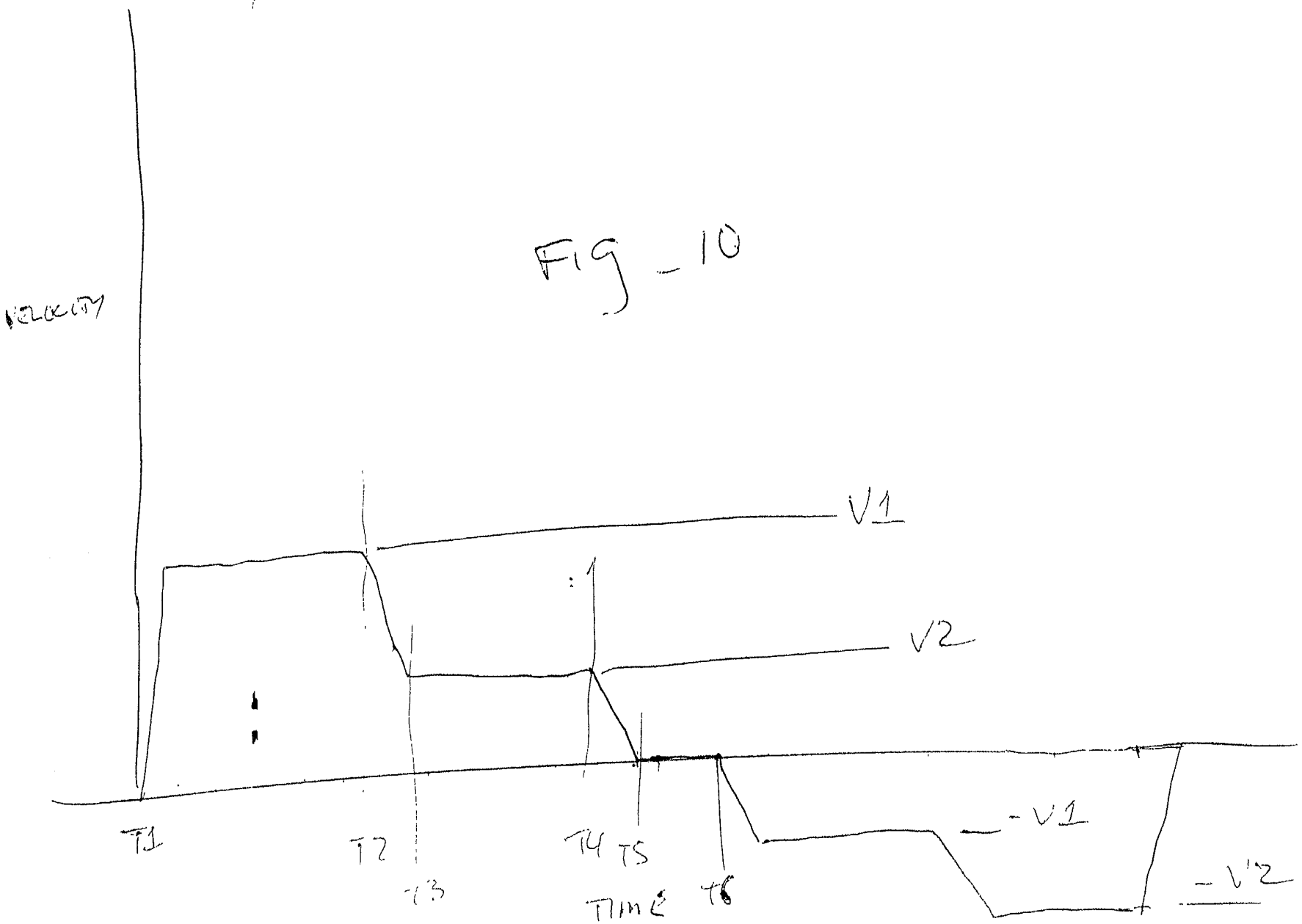


Fig - 9

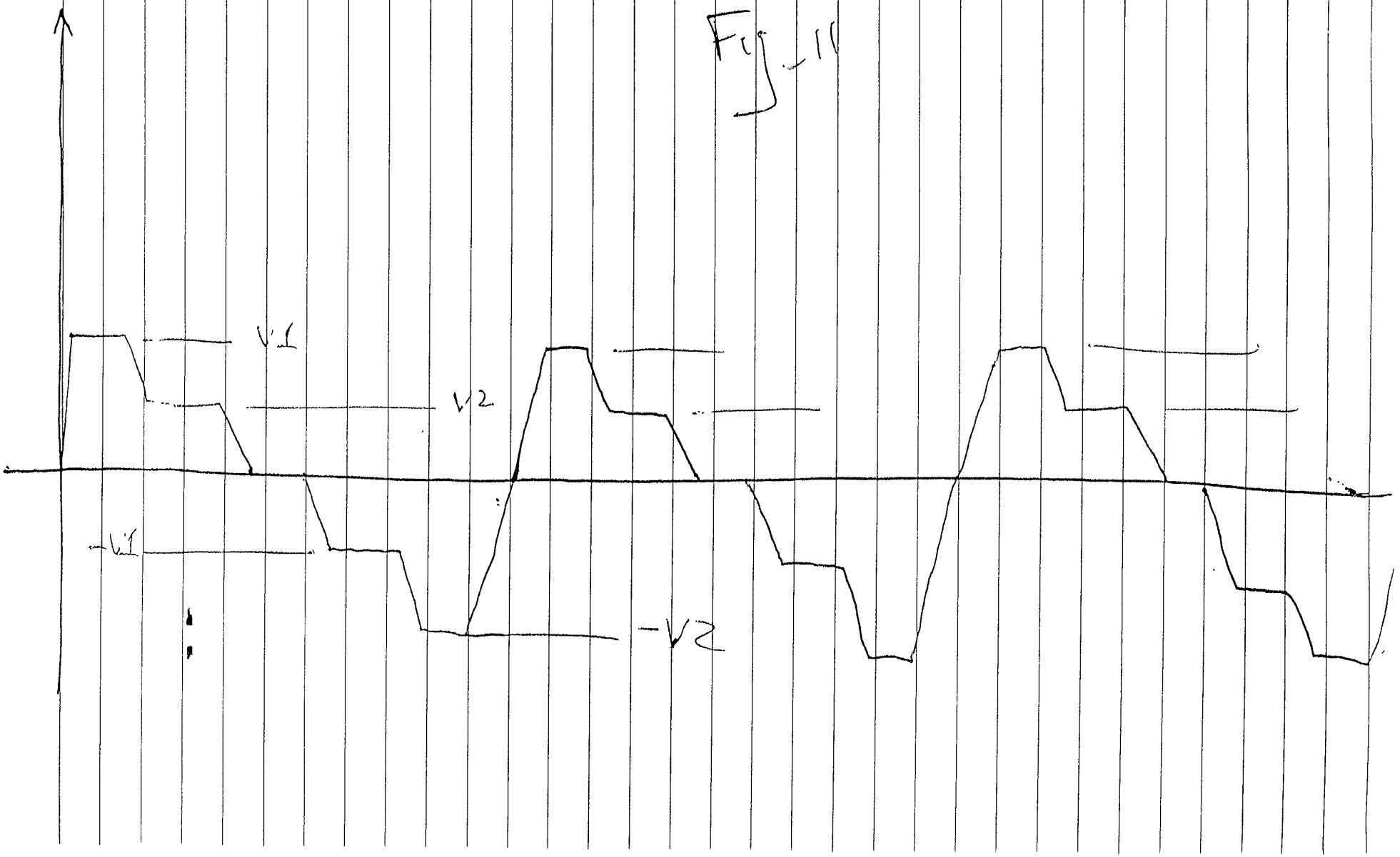
TOSOZT' PZ4SOOOT

Fig - 10



PATENT-2134-0001

Fig. 11



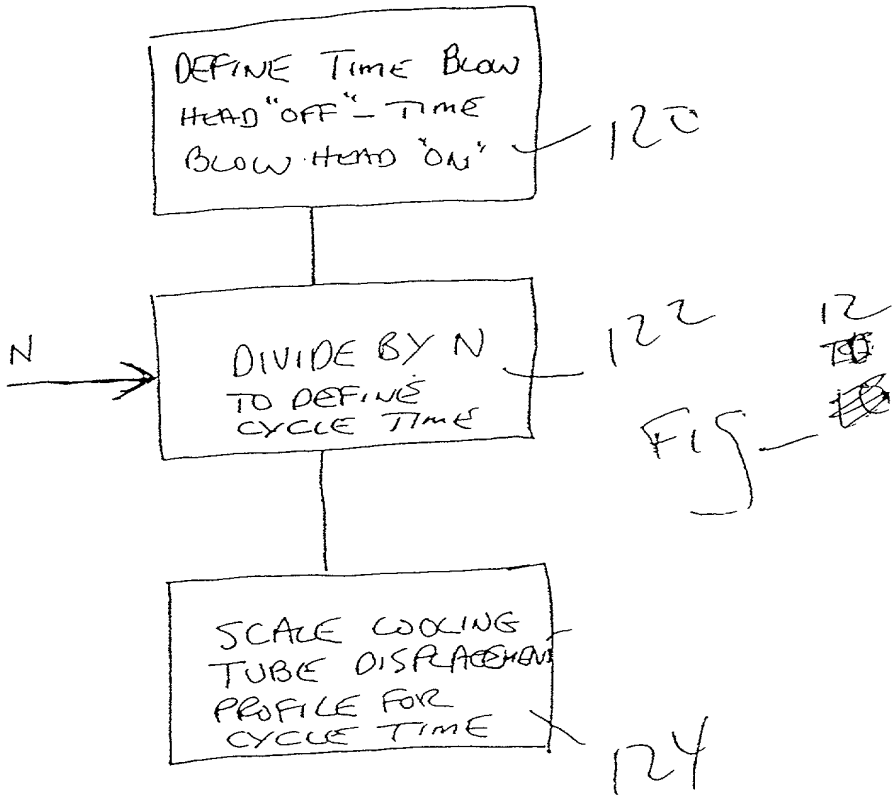

DEFINE TIME BLOW HEAD "OFF" – TIME BLOW HEAD "ON"
120
N
DIVIDE BY N TO DEFINE CYCLE TIME
122
SCALE COOLING TUBE DISPLACEMENT PROFILE FOR CYCLE TIME
124

FIG 12

PO5021 T24S0001

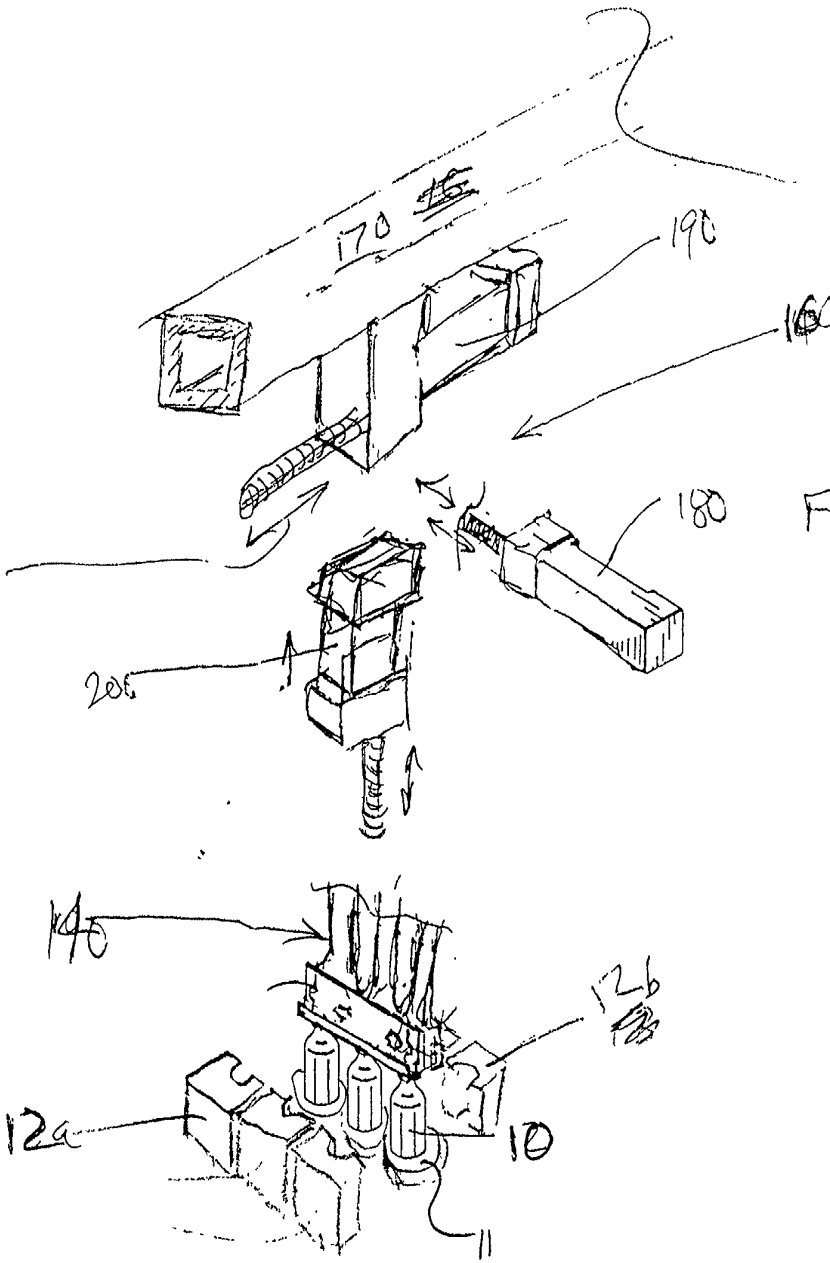


Fig. 13

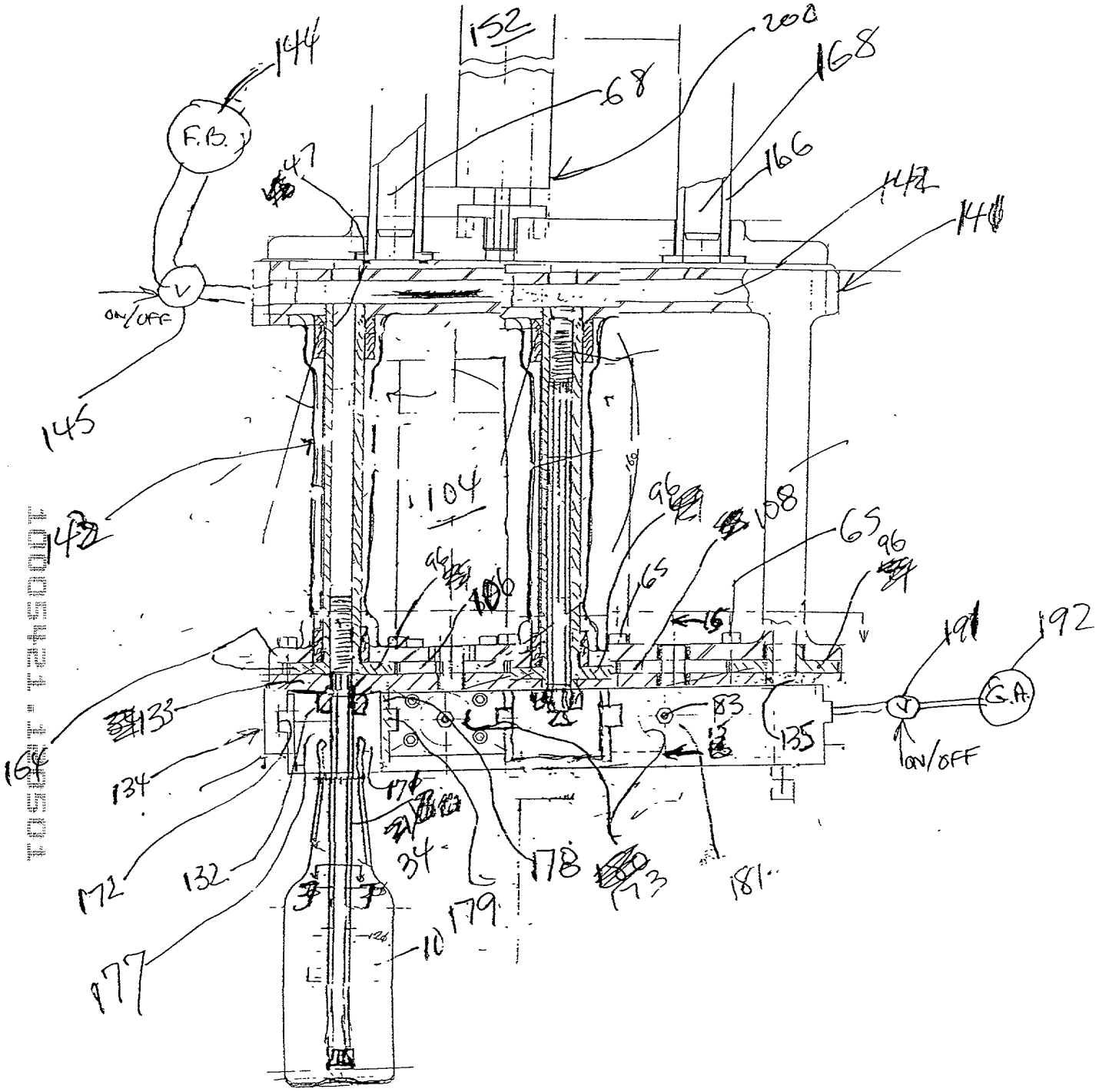

152
200
168
68
166
144
F.B.
147
142
140
V
ON/OFF
145
142
104
96
108
65
96
106
65
96
191
192
133
83
135
G.A.
V
ON/OFF
166
134
172
132
177
174
34
178
179
173
181
10

Fig - 14

187
174
175
183
184
188
181
176
186
182
186
176
188
133
188
183
184
187
174
175

Fig. 15

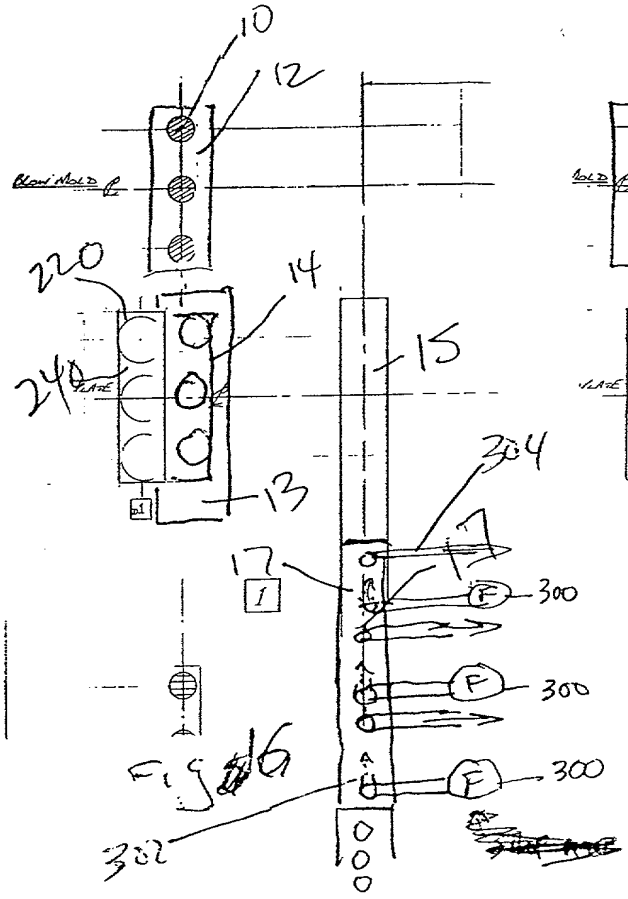


Fig 16

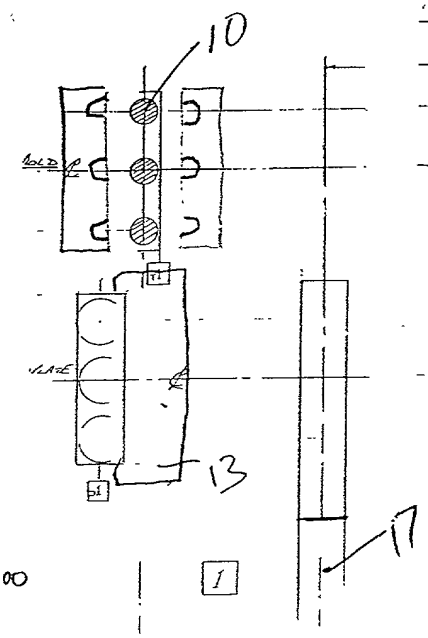


Fig 17B

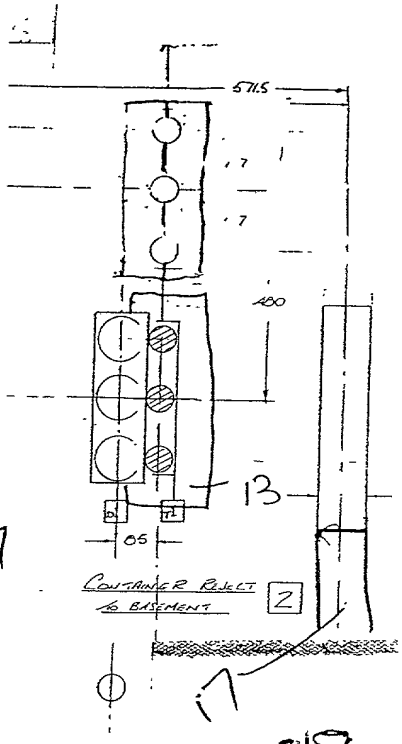


Fig 18

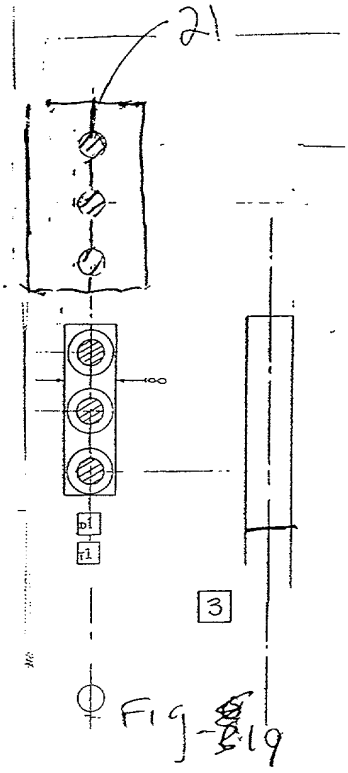


Fig 19

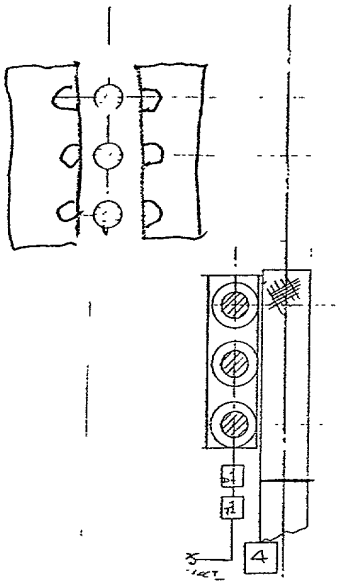


Fig 20

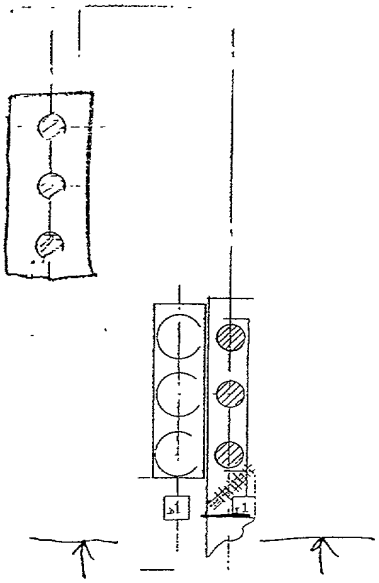


Fig 21

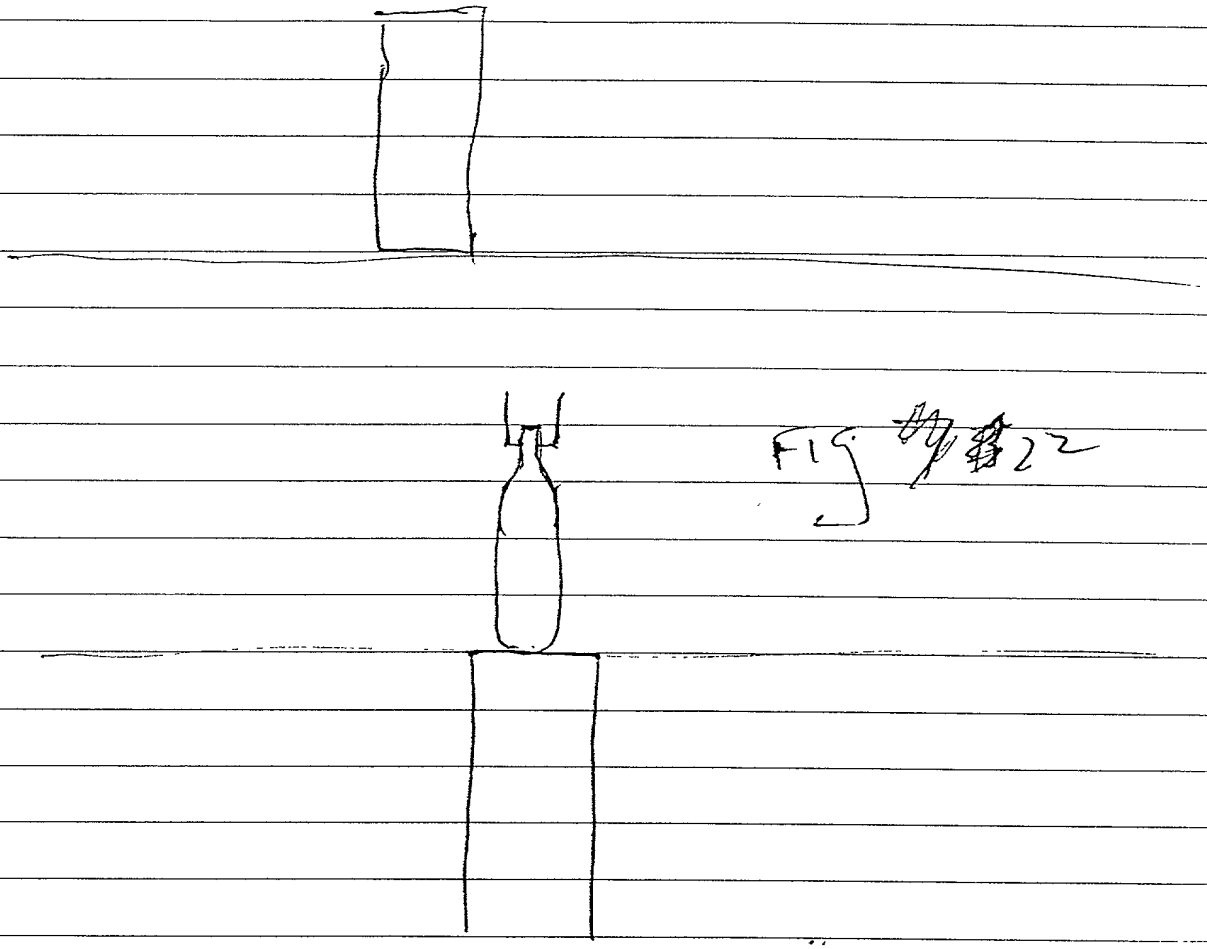


Fig 第22

T05027 T2ms0001

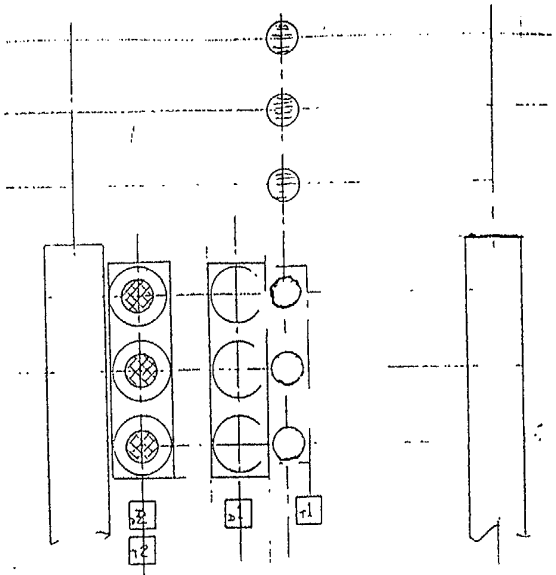


Fig-23

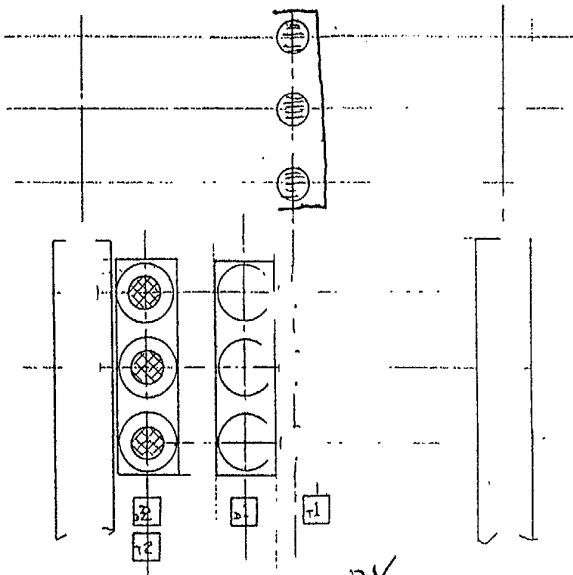


Fig-24

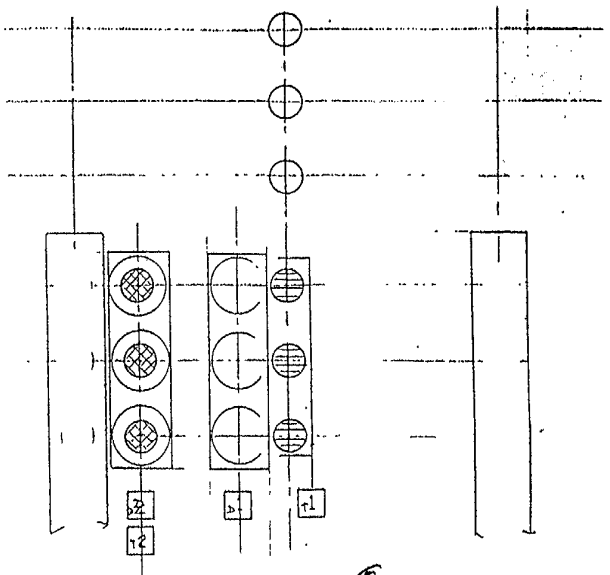


Fig-25

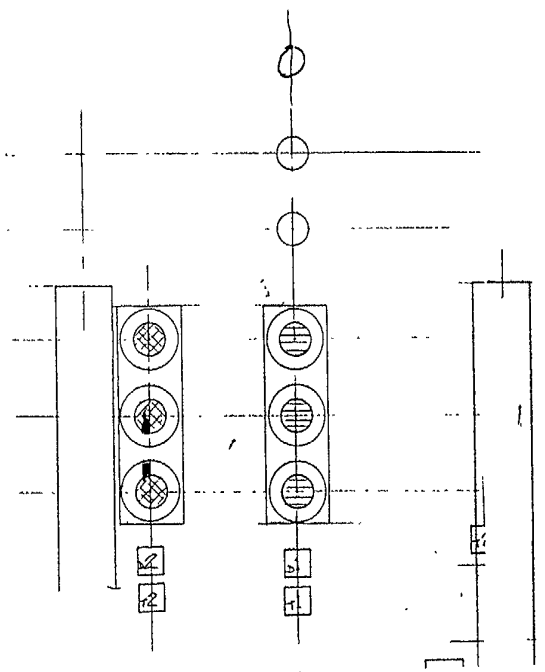


Fig-26

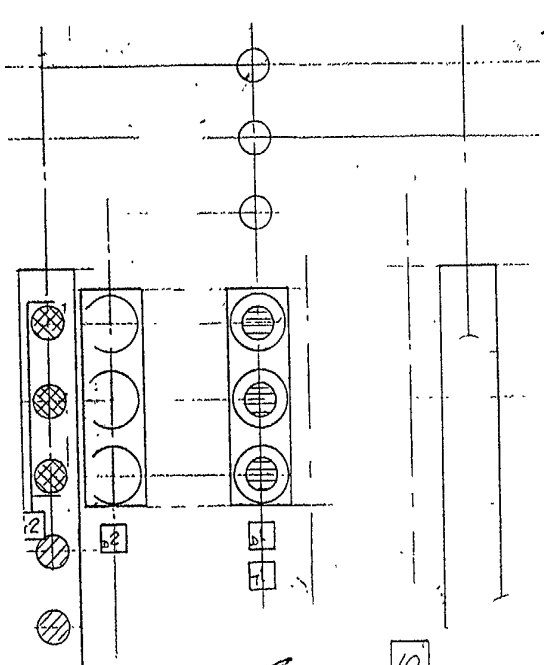


Fig-27

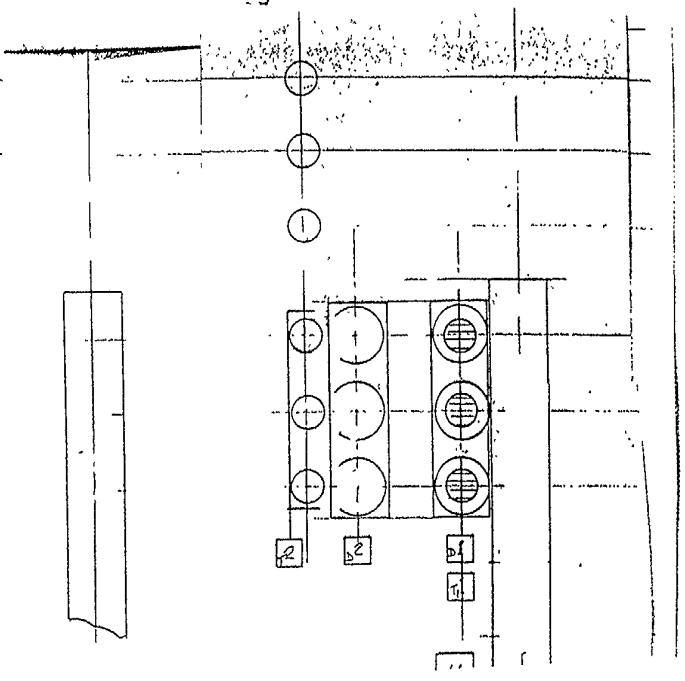


Fig-28

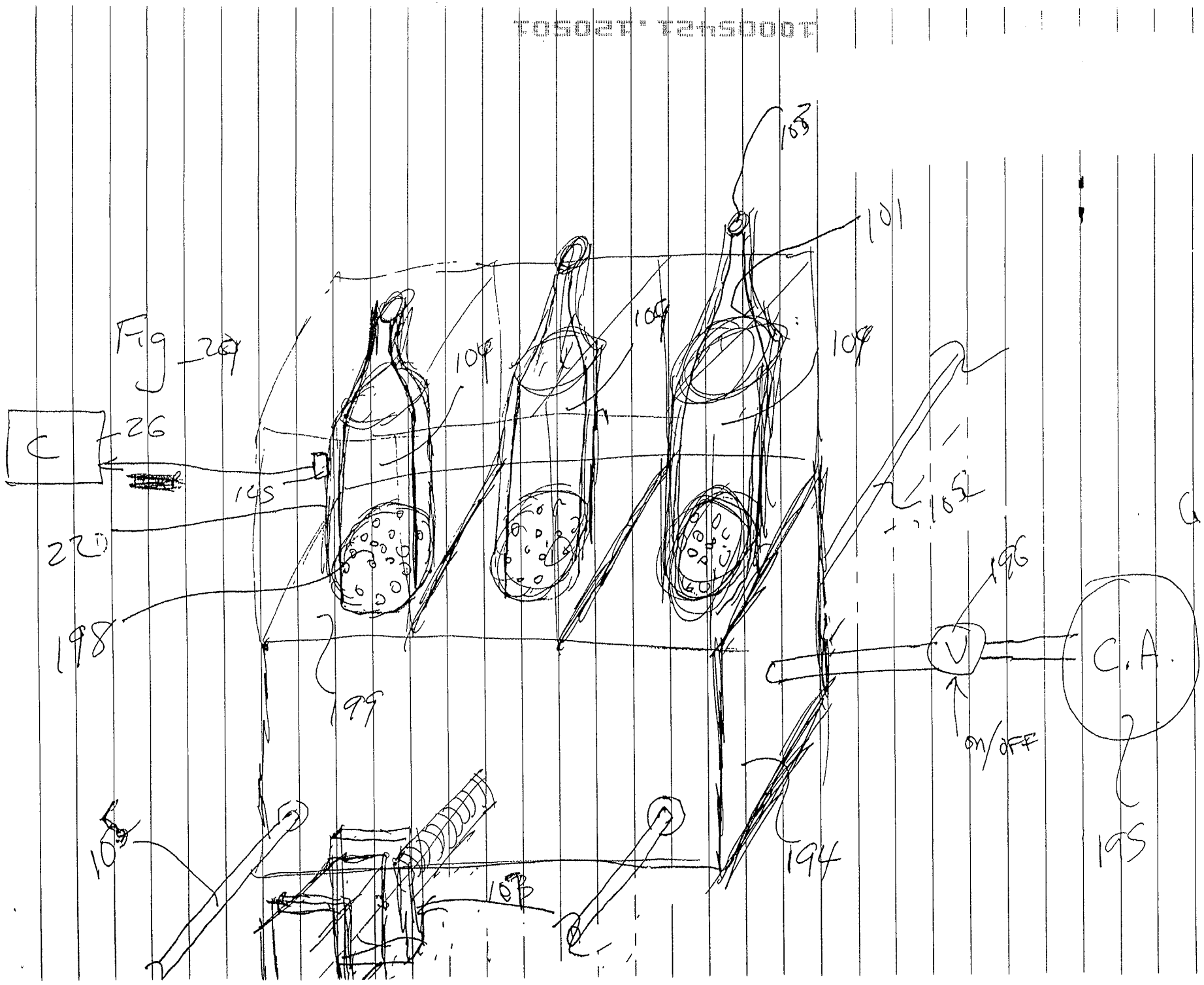


Fig 29
C
26
105
101
104
104
104
105
27
198
199
196
V
C.A.
on/off
194
195
107
107

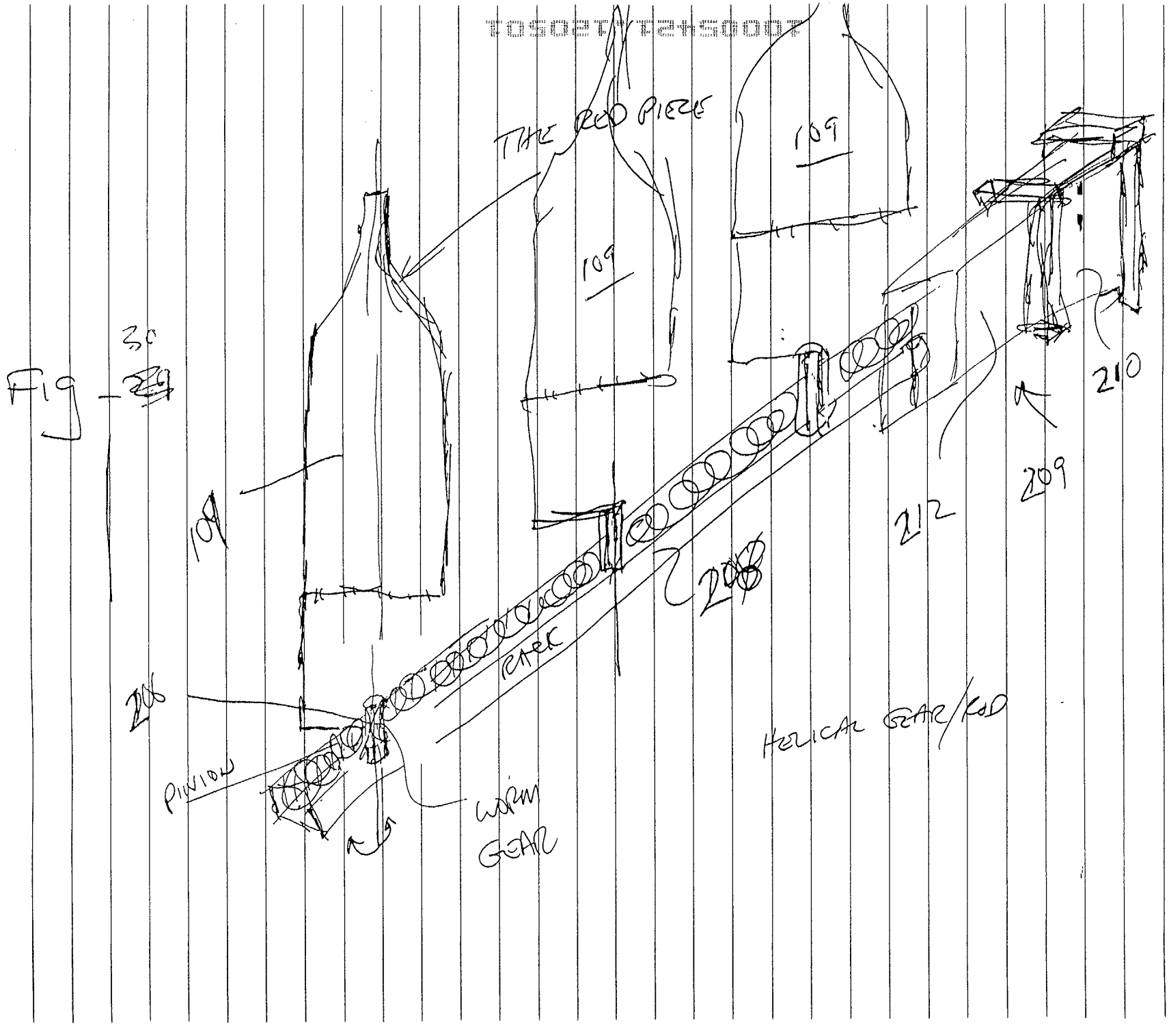

THE ROD PIECE
109
109
109
210
209
212
208
208
PIPE
PINION
WORM GEAR
HELICAL GEAR/ROD

Fig - 30

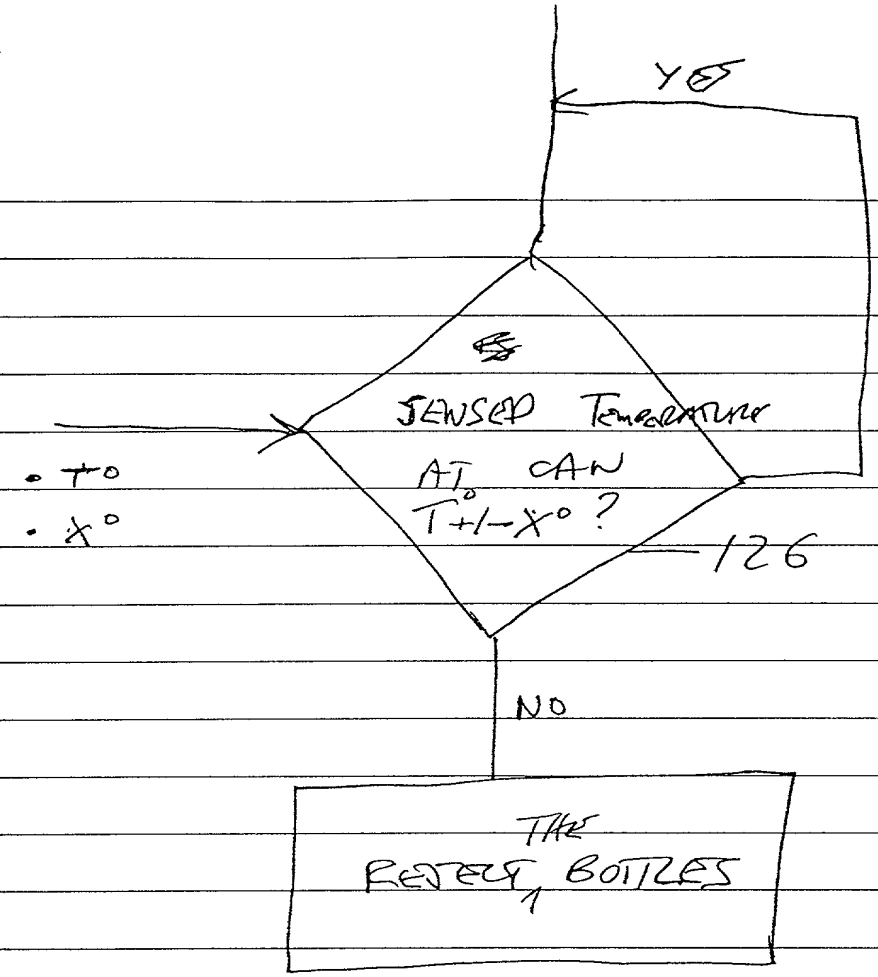
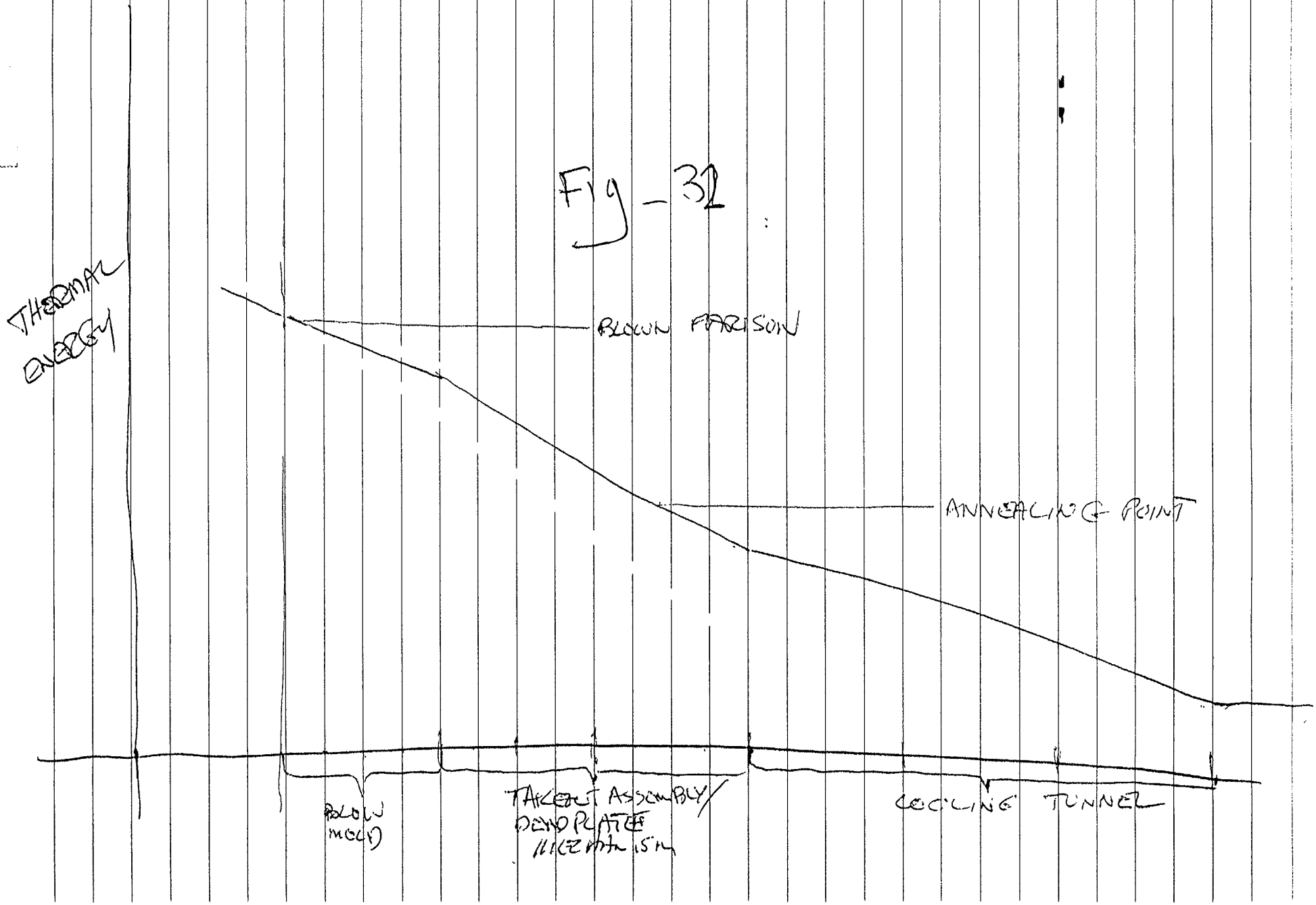

YES
SENSED Temperature
AT CAN
T+/-X° ?
126
• T°
• X°
NO
TAKE
REJECT BOTTLES

Fig - 31

Fig - 32


THERMAL ENERGY
BLOWN PARISON
ANNEALING POINT
BLOW MOLD
TAKEOUT ASSEMBLY/ DEND PLATE
COOLING TUNNEL